

Date: Monday, 6/9/2008 2:42:15 PM
 User: David Duval

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HANDLE ASSEMBLY (EXTERIOR)
Job Number : 05032	
Estimate Number : 13371	
P.O. Number :	Part Number : D3779041
This Issue : 6/9/2008 S.O. No. :	Drawing Number : PROTO
Prsht Rev. : NC	Project Number : N/A
First Issue : 6/9/2008 Type : R & D SM/MED FAB	Drawing Revision : PROTO
Previous Run :	Material :
Written By : <u>M 08/06/09</u>	Due Date : 6/16/2008 Qty: <u>2</u> Um: Each
Checked & Approved By :	
Comment : Est Rev:A 08-06-09 new issue DD verified by:ec	

Additional Product

PROTOTYPE

Job Number:



FOR ENGINEERING USE ONLY

Seq. #: Machine Or Operation: Description :

1.0 M6061T6S125 6061-T6 .125 Sheet



Comment: Qty.: 0.2037 sf(s)/Unit Total : 0.2037 sf(s)

6061-T6 .125 Sheet

batch: 105646RB 8-6-10

(2)

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3779

Dwg Rev: PROTOProg Rev: PROTORB 8-6-10

2-Deburr if necessary

RB 8-6-10

(2)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE

RB 8-6-10

(2)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK

RB 8-6-10 (2)

Comment: SECOND CHECK

5.0 PACKAGING 1 PACKAGING RESOURCE #1

eng lab

Comment: PACKAGING RESOURCE #1

Pick Packing Kit

Date: Monday, 6/9/2008 2:42:15 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE ASSEMBLY (EXTERIOR)

Job Number: 05032

Part Number: D3779041

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

D32031

Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Handle

batch: 830158A

FF 08-06-10

(2)

7.0

MS20426AD10 18

Rivet Countersunk



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Rivet Countersunk

batch: M 107936

or (MS20426AD10-10)

FF 08-06-10

(2)

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- counter sink holes as per dwg D3779

2- deburr

3- rivet D3203-1 handle to D3779-1 plate as per dwg D3779 per QSI003

FF 08-06-10

(2)

9.0

QC5

INSPECT WORK TO CURRENT STEP



AS3

ENGINEERING
APPROVAL



P10

Comment: INSPECT WORK TO CURRENT STEP

08-06-10 (1)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



FOR ENGINEERING USE ONLY



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location: _____

Eng 126

11.0

QC21

FINAL INSPECTION/W/O RELEASE



08/06/11

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



change to w/o # 00220

u 08-06-11

PROTOTYPE REQUEST FORM

DART Aerospace Ltd.

Product #: 412-698

Job #: 00220

Date: 08.06.09

Product Name: Door Modifactions

Requested By: AJS

Design Manager Approval: 

Quantity	Part Number	Category	Description	Drawing Date	Material Cert Req'd?	Due Date	Comments	Date Completed
1	D3779-041	SMFAB	Handle Handle Assy	08.04.21	No	08.06.10	Do Not Finish	

-DART AEROSPACE LTD	Work Order:	05032
Description: HANDLE ASSEMBLY (EXTERIOR)	Part Number:	D3779-041
Inspection Dwg: D3779-041 Rev: PROTO TYPE		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article** ☐ **Prototype**

[illegible]

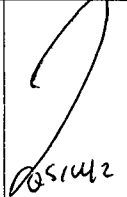

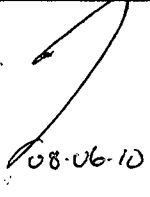
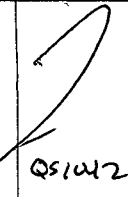
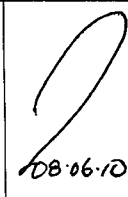
Measured by: HB	Audited by: [Signature]	Prototype Approval:
Date: 9-6-11	Date: 88-06-00	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3779-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

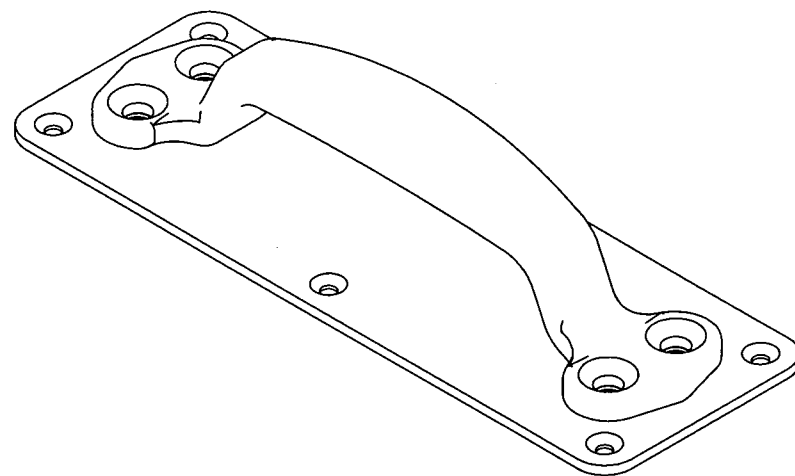
QA: N/C Closed: _____ Date: _____

NCR: 05032		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-06-10	B.O	1 part scrap. The handle split while riveding. R.c: Rivet was pressed too much forcing the rivet into the handle.		Scrap: destrat, no replace.				

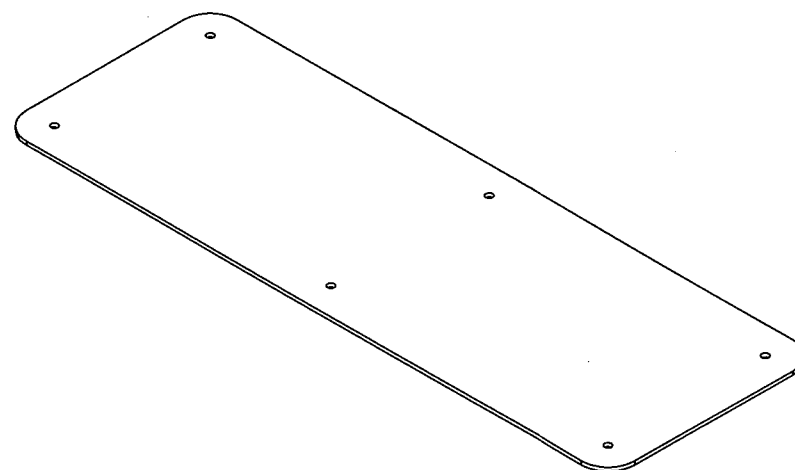
NOTE: Date & initial all entries

QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
X		D3779-041	HANDLE ASSEMBLY
	X	D3779-043	HANDLE ASSEMBLY
1	1	D3203-1	HANDLE
1		D3779-1	PLATE
	1	D3779-5	PLATE
4	4	MS20426AD10-10	RIVET, CSK

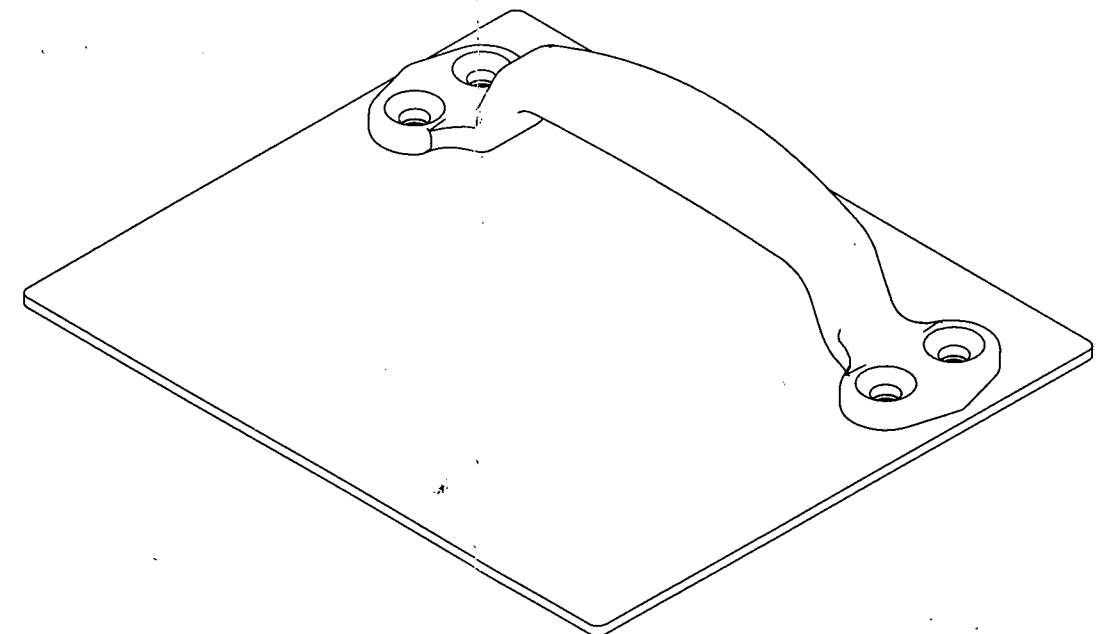
PROTOTYPE
PLEASE RETURN
DATA TO
AJS 0806.07



D3779-041 HANDLE ASSEMBLY
(EXTERIOR)

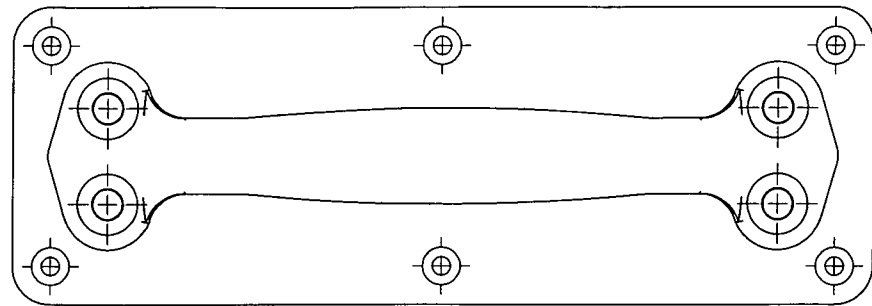


D3779-3 DOUBLER PLATE

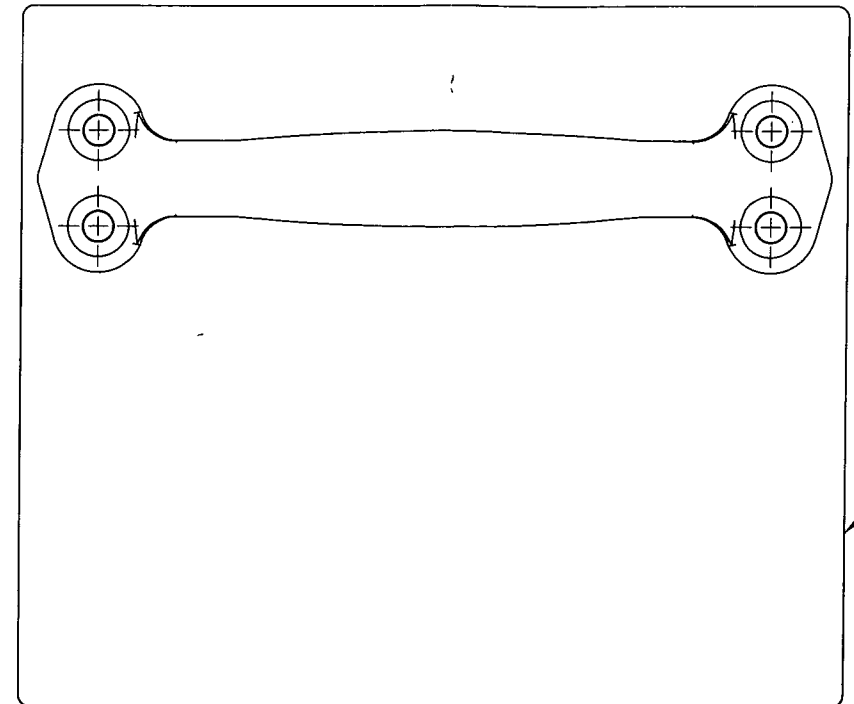


D3779-043 HANDLE ASSEMBLY
(INTERIOR)

A	NEW ISSUE		AJS	08.04.21
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED		DRAWING NO.		REV. A
MFG. APPR.		D3779		SHEET 1 OF 4
APPROVED		TITLE		SCALE
DE APPR.		HANDLE ASSEMBLY, CABIN SLIDING DOOR		NTS
DATE	08.04.21		COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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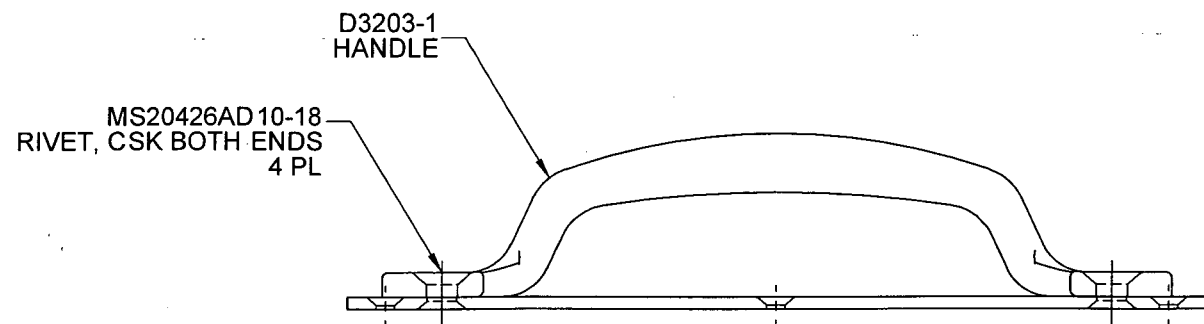


D3779-1
PLATE

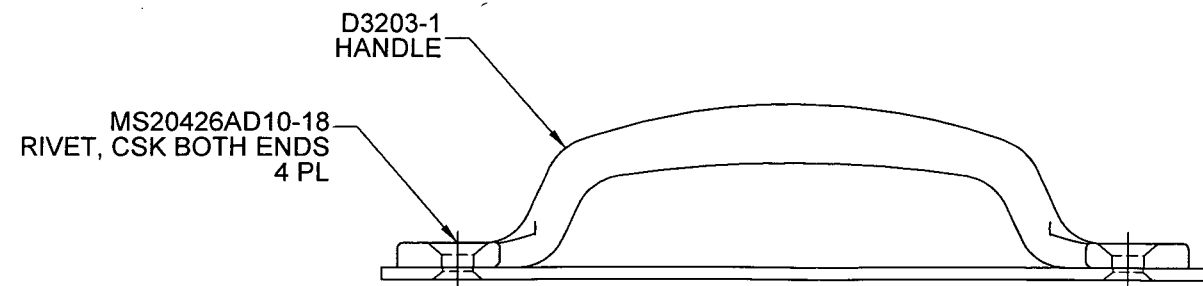


D3779-5
PLATE

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
AJS 08.06.09



D3779-041 HANDLE ASSEMBLY
(EXTERIOR)

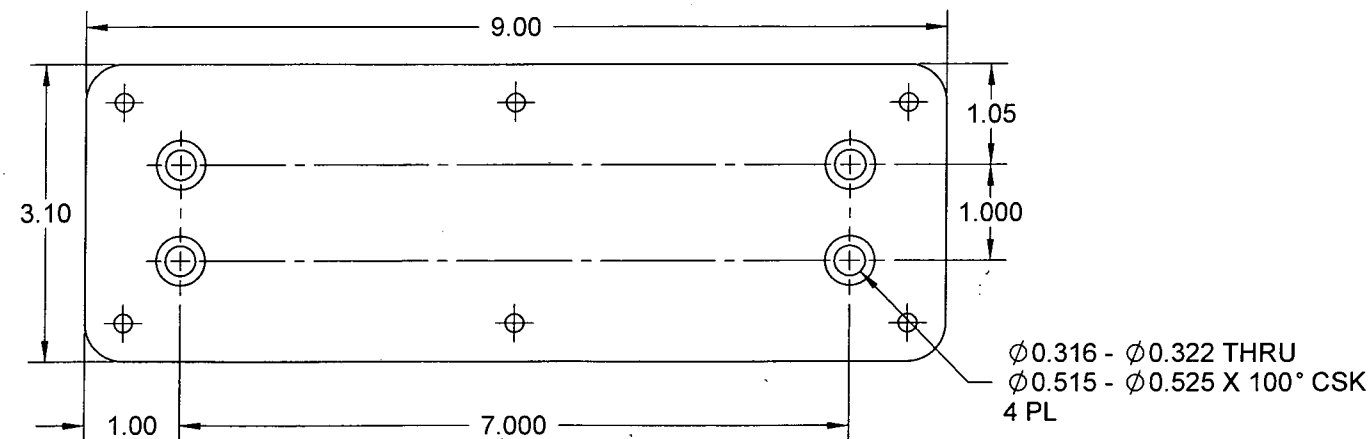
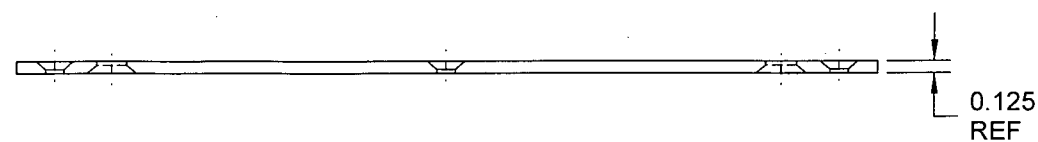
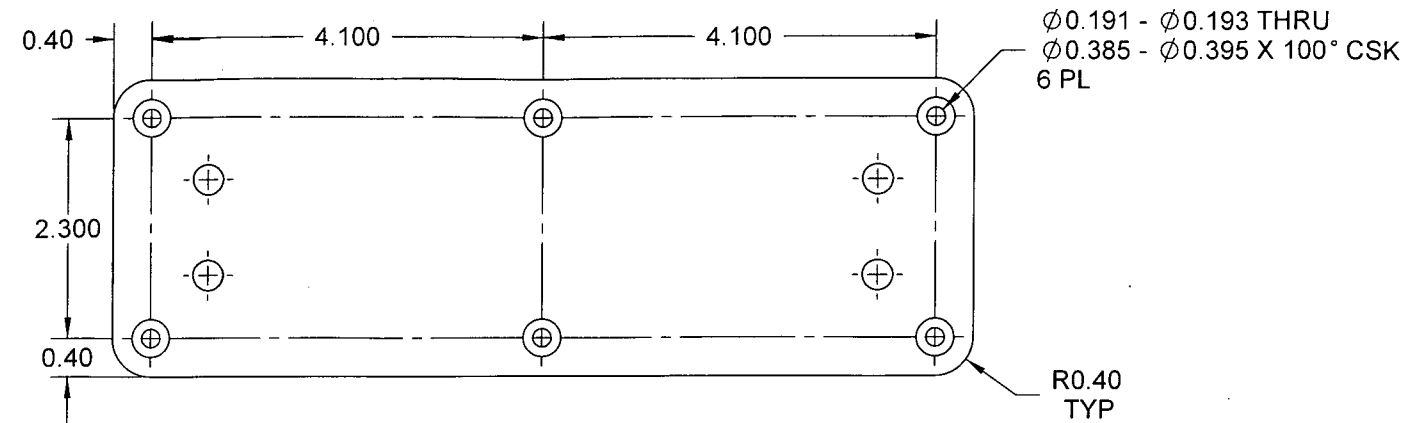


D3779-043 HANDLE ASSEMBLY
(INTERIOR)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: PRIME PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3779-041" USING FINE POINT PERMANENT INK MARKER
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3779-043" USING FINE POINT PERMANENT INK MARKER
- 8) WEIGHT: 1.50 lbs APPROX (-041)
- 9) WEIGHT: 1.85 lbs APPROX (-043)

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D3779	REV. A
MFG. APPR.			SHEET 2 OF 4
APPROVED		TITLE HANDLE ASSEMBLY, CABIN SLIDING DOOR SCALE NTS	
DE APPR.			
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D3779-1 PLATE

NOTES:

1) MATERIAL: -1 PLATE:

6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK
 PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
 (REF DART SPEC M6061T6S.125)

-3 PLATE:

6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.050 THICK
 PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
 (REF DART SPEC M6061T6S.050)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 PRIME PER DART QSI 005 4.2 -3 ONLY
 (-1 TO BE PRIMED ON ASSEMBLY)

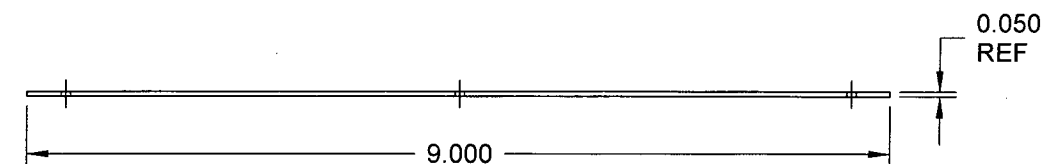
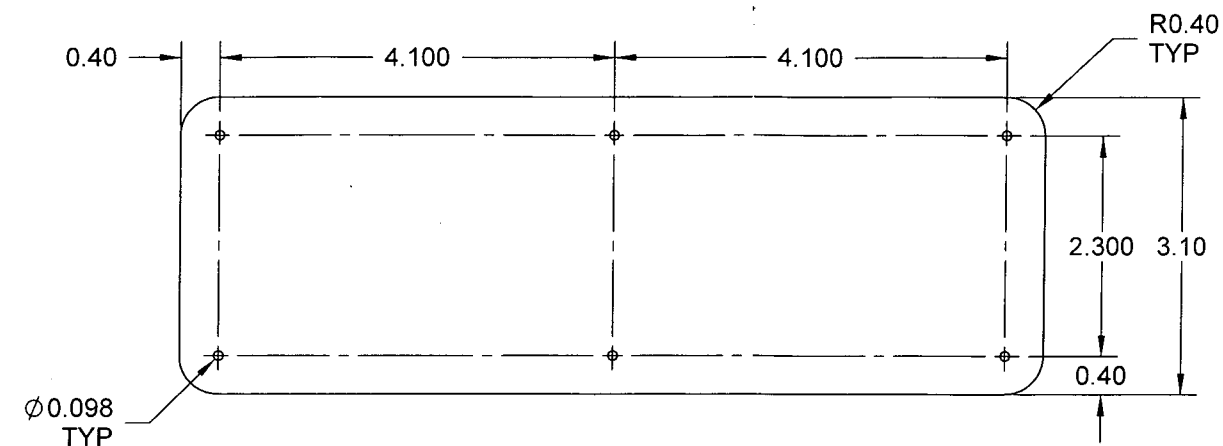
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3779-3" USING FINE POINT PERMANENT INK MARKER
 (DO NOT IDENTIFY -1 & -5)

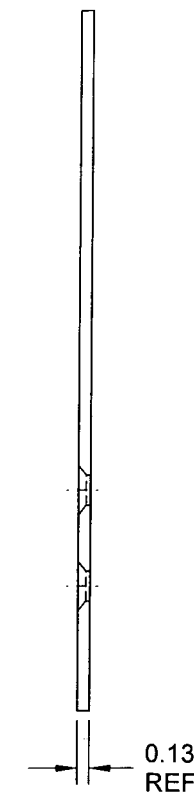
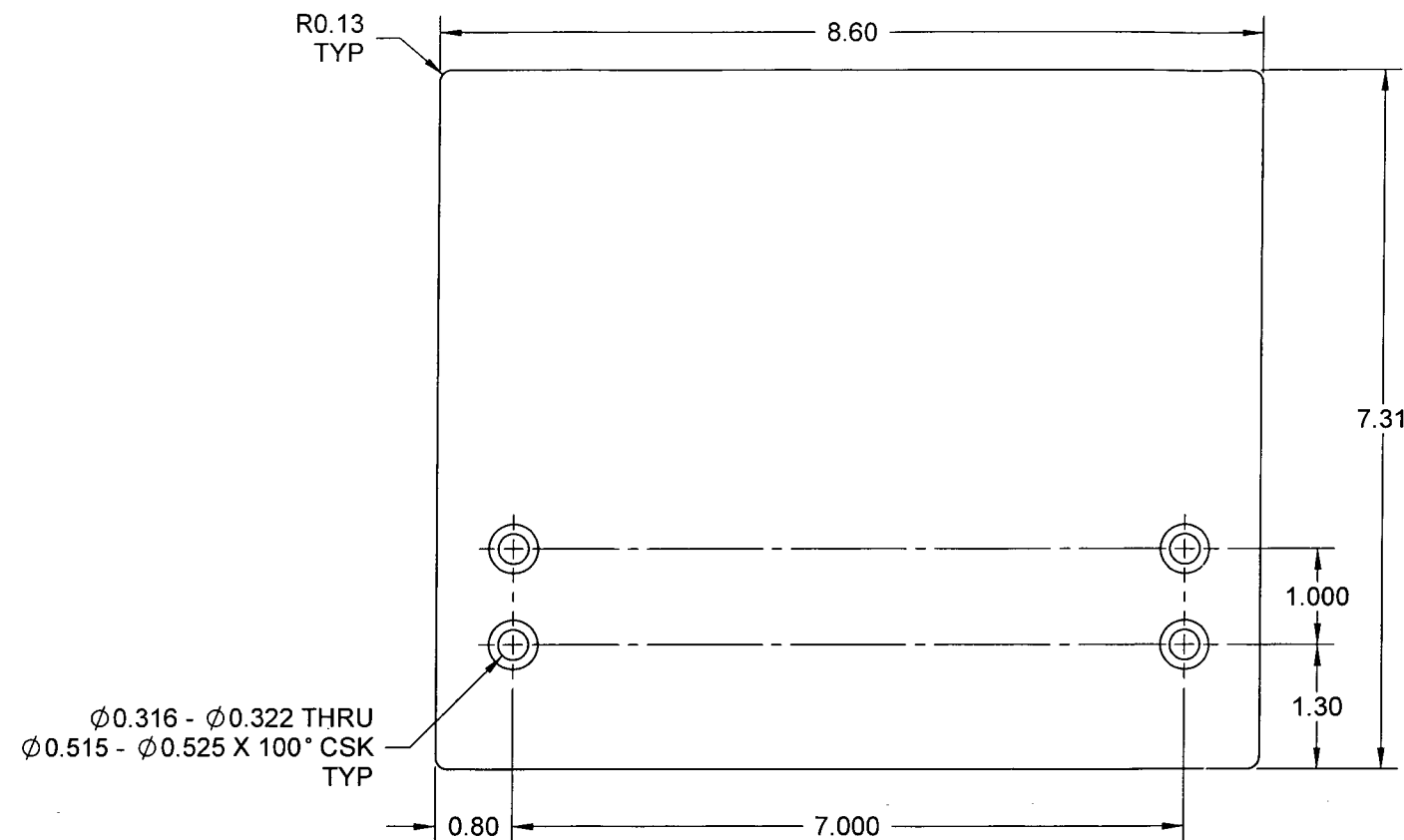
7) WEIGHT: 0.14 lbs FOR -3.



D3779-3 PLATE

PROTOTYPE
 PLEASE RETURN ALL ISSUED
 DATA TO ENGINEERING
 AJS 08.06.09

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3779	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		HANDLE ASSEMBLY, CABIN SLIDING DOOR	NTS
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NOTES:

- 1) MATERIAL: -5 PLATE:
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF DART SPEC M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
(-5 TO BE PRIMED ON ASSEMBLY)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE SHEET 2 FOR ASSEMBLED WEIGHT

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
ASS 08.06.21

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3779	SHEET 4 OF 4
APPROVED		TITLE HANDLE ASSEMBLY, CABIN SLIDING DOOR SCALE NTS	
DE APPR.			
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